

Appl. No. # 10/672,463
Amdt. dated 01/13/2005
Reply to OA of 10/27/2004

CLAIMS

1. (original) A method of making a titanium golf club head comprising the steps of:
 - a. putting a semi-finished club head into a mold, the semi-finished club head comprising the parts of: a striking face, sole, crown, and shaft;
 - b. molding the parts together in a sonic stove;
 - c. forging the parts in a forging machine;
 - d. processing the surface of the club head.
2. (currently amended) The method in claim 1 wherein the forging temperature is 920 degrees Celsius when using [[Ti-6-4]] Ti-6Al-4V as forging material.
3. The method in claim 1 wherein [[the]] reacting speed of the titanium golf club head is in the range from .1s to .001s.
4. (original) A method of making a titanium golf club head comprising the steps of:
 - a. adopting Titanium alloy as SPDF material under isothermal forging conditions,
 - b. putting semi-finished workpieces including a striking face, sole, crown, and shaft into a mold,
 - c. setting the SPDF temperature at between 870-970 degrees Celsius, while heating the mold and workpieces simultaneously in a high frequency stove,
 - d. moving the mold and workpieces from the stove to the forging machine,
 - e. adjusting the forging machine reacting speed rate within the range of $10^{-2}/s$ to $10^{-4}/s$.
5. (original) The method of claim 4 wherein the thickness of the club sole varies from 1.0 mm to 1.3 mm, wherein the crown section has relatively uniform thickness.
6. (currently amended) The method in claim 4 wherein the forging temperature is about 920 degrees Celsius when using [[Ti-6-4]] Ti-6Al-4V as forging material.
7. (original) The method in claim 4 wherein the reacting speed is in the range from .2s to .002s.
8. (currently amended) The method in claim 4 wherein the titanium is [[Ti-6-4]] Ti-6Al-4V.